

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022347**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3013

Weld No: 012

Welder: 066038

WPS-B-P-2214-B-U2-FCM-1

Components; OBG 14 W

PCMK: SEG3013R

Weld No: 004,005

Welder: 037780

WPS-B-P-2113-B-U2-FCM-1

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## WELDING INSPECTION REPORT

( Continued Page 2 of 5 )

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Components; OBG 14 W  
PCMK: SEG3013E  
Weld No: 225  
Welder: 047864  
WPS-B-P-2113-B-U2-FCM-1

Components; OBG 14 W  
PCMK: SEG3013J  
Weld No: 006  
Welder: 067993  
WPS-B-P-2113-B-U2-FCM-1

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13 W  
PCMK: SEG3013  
Weld No: 097,100,152,155  
Welder: 203871  
WPS-B-T-2233-ESAB

Components; OBG 13 W  
PCMK: SEG3013Q  
Weld No: 191,194  
Welder: 067876  
WPS-B-T-2233-ESAB

Components; OBG 13 W  
PCMK: SEG3013M  
Weld No: 173,176  
Welder: 066421  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Submerged Arc Welding (SAW) process.  
ZPMC QC is identified as Zhong Yong Gung, CWI Liang Biao.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

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## WELDING INSPECTION REPORT

( Continued Page 3 of 5 )

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PCMK: SEG3007  
Weld No: 010  
Welder: 062406  
WPS-B-P-2221-B-L2C-S-2

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhong Yong Gung, CWI Liang Biao.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14AE  
PCMK: SEG3019AB  
Weld No: 136  
Welder: 054013  
Weld Repair No. B-WR20361  
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14AE  
PCMK: SEG3019Z  
Weld No: 007  
Welder: 044779  
Weld Repair No. B-WR20361  
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14AE  
PCMK: SEG3019AA  
Weld No: 028  
Welder: 058087  
Weld Repair No. B-CWR2755  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14AE  
PCMK: SEG3019AJ  
Weld No: 053,058  
Welder: 216086  
Weld Repair No. B-WR20245  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14AE  
PCMK: SEG3019AJ  
Weld No: 096  
Welder: 215553  
Weld Repair No. B-WR20245

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## WELDING INSPECTION REPORT

( Continued Page 4 of 5 )

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WPS-345-SMAW-3G(3F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gung, CWI Liang Biao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AE

PCMK: SEG3007G

Weld No: 049

Welder: 050242

WPS-B-T-2233-ESAB

Components; OBG 13AE

PCMK: SEG3007J

Weld No: 048

Welder: 050242

WPS-B-T-2233-ESAB

Components; OBG 13AE

PCMK: SEG3007L

Weld No: 046

Welder: 050242

WPS-B-T-2233-ESAB

Components; OBG 13BE

PCMK: SEG3007AV

Weld No: 049,050

Welder: 055564

WPS-B-T-2233-ESAB

Components; OBG 13CE

PCMK: SEG3007AZ

Weld No: 076,077

Welder: 053491

WPS-B-T-2233-ESAB

Components; OBG 14AE

PCMK: SEG3019B

Weld No: 029~039

Welder: 051356

WPS-B-T-2233-ESAB

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## WELDING INSPECTION REPORT

( Continued Page 5 of 5 )

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This QA Inspector performed document review for information requested by James Devy, and the Office of Structural Materials. This information request addresses OBG 14 west and 14 east anchorage plate assembly AP3031 and AP3032. This QA Inspector performed random visual inspections of the weld size, cope hole size and condition listed in the information request form. It appears to this QA Inspector ZPMC has completed the welds as referenced in the request. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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